

Work Order ID 92289

Thursday, October 25, 2012 1:42:42 PM

92289

Ship Friday

Page 1

Item ID: D412-705-015 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Driveshaft Tunnel Modification
 Start Date: 10/25/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/26/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MKE Date: 12-10-25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev C

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D412-705-015

0.00

0.00

CHG 005

CHG 003

★ SEE
Attached

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

12/10/26 JB

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

DAS 16 12/6/26

rc

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: <u>92289</u> Part No. <u>D 412-705-015</u> NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input checked="" type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	12/10/26	100	1	BECAUSE OF NEW GASKET MAT'L, CHG NUMBER IS CHG 005 Perman. Change	DAS 12 12/10/26	Update all paperwork to say CHG 005 PER ATTACHED EMAIL.	 12/10/01	 12/10/01	DAS 16 12/10/30		

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 92289***92289***

Page 2

Thursday, October 25, 2012 1:42:42 PM

Item ID: D412-705-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Driveshaft Tunnel Modification

Start Date: 10/25/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-705-015 Location: _____ PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

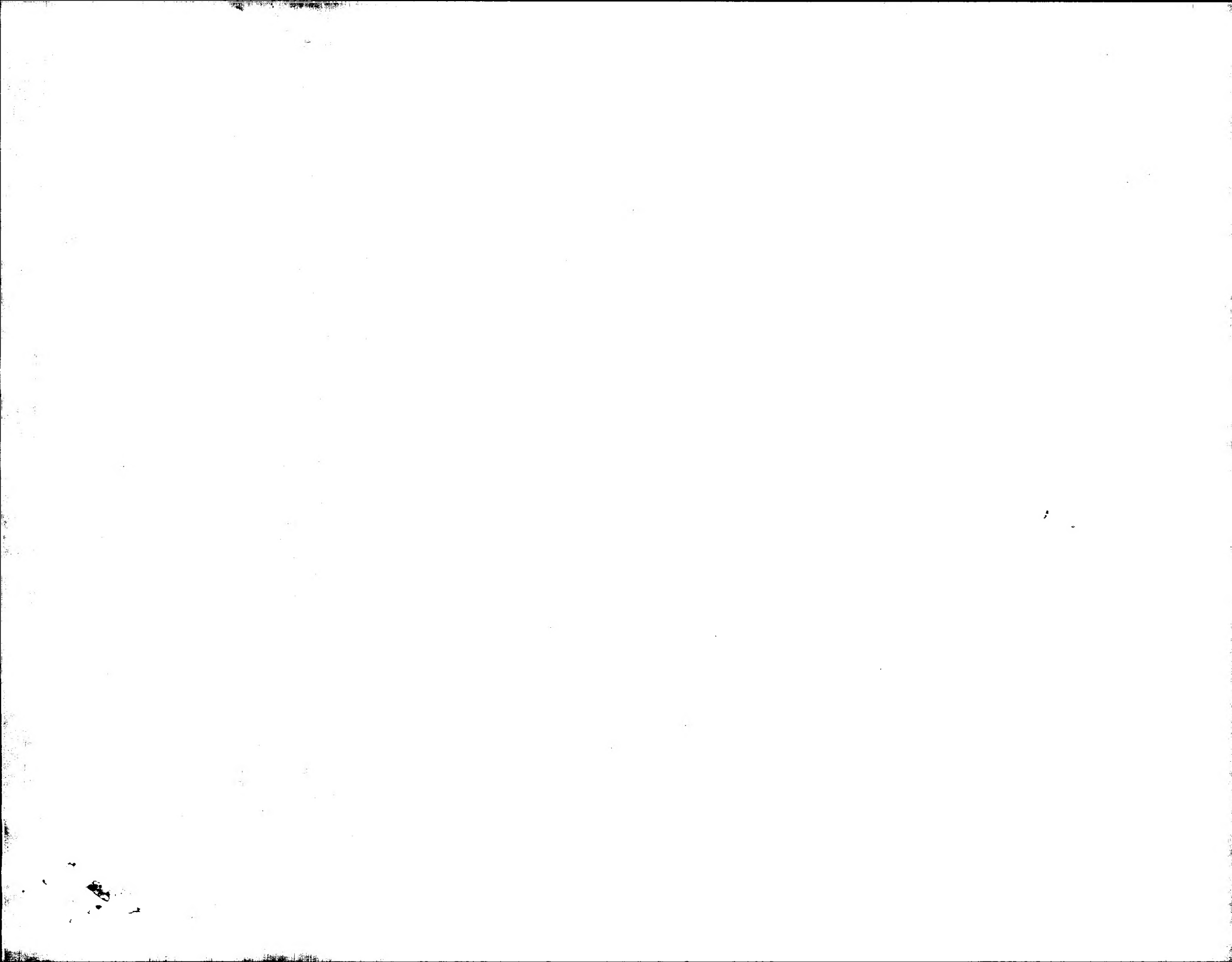
0.00

Quality Control

ML5 12-10-26

MF

12-10-26



Picklist Print

Thursday, October 25, 2012 1:42:41 PM

Page 1

Work Order ID: 92289

Parent Item: D412-705-015

Parent Item Name: Driveshaft Tunnel Modification







Start Date: 10/25/2012

Required Date: 10/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Removed Manufacturing 06-10-03 JLM
IPP Rev:C ECN 1052 07-11-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 AN3C3A Bolt		Purchased	No			120	Each	532.0000		22	✓	JB	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		38							
				118352		38							
				ST350		494							
				120187		1							
				122141		113			122141				
				123203		380							
 AN3C4A BOLT		Purchased	No			120	Each	1,222.0000		3	✓	JB	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		1222							
				120187		31							
				120521		28							
				120769		38							
				121205		61							
				121556		8							
				122151		2							
				122416		4							
				122814		920			122814				
				123021		130							
 D3256-1 Panel		Manufactured	No			120	Each	1.0000		1	✓	JB 12/10/26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST176		1							
				89125		1			89125				

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
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Picklist Print

Thursday, October 25, 2012 1:42:41 PM

Page 2

Work Order ID: 92289

Parent Item: D412-705-015

Parent Item Name: Driveshaft Tunnel Modification

Start Date: 10/25/2012

Required Date: 10/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3256-3
Gasket

Manufactured No

120 Each 1.0000

0

1

Location

Loc Qty

Loc Code

ST176

1

66792

1

No good

120

Each

1,855.0000

44

9,2288

12114

44

MS20427M3-3
Rivet

Purchased

No

Location

Loc Qty

Loc Code

GA

1840

123352

1840

ST318

3

120930

3

ST335

12

123021

12

MS21060-L3K
Nut Plate

Purchased

No

120

Each

225.0000

22

22

Location

Loc Qty

Loc Code

ST303

95

120142

95

ST316

128

123280

128

ST319

2

122141

2

123280

MS9321-09
Washer

Purchased

No

120

Each

380.0000

25

25

Location

Loc Qty

Loc Code

ST296

380

119546

50

120142

2

121524

1

122141

327

122141

Thursday, October 25, 2012 1:42:41 PM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
16	44	36			12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
8	22	18			6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
	25	30			6		MS9321-09	WASHER

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Revision: C

Date: 07.10.12

Marc Bellavance

From: David Shepherd <dshepherd@dartaero.com>
Sent: Friday, October 26, 2012 4:42 PM
To: 'Mike Petsche'; 'Chris Provencal'
Cc: 'Marc Bellavance'; 'L Lacelle'
Subject: RE: Drive shaft tunnel gasket change
Attachments: RE: lead time for d412-705-015 (20.6 KB)

Follow Up Flag: Follow up
Flag Status: Completed

The original approval email is attached. CHG 005 makes sense to me as well.

David

From: Mike Petsche [<mailto:mpetsche@dartaero.com>]
Sent: October-26-12 11:57 AM
To: Chris Provencal
Cc: David Shepherd; Marc Bellavance; L Lacelle
Subject: Re: Drive shaft tunnel gasket change

I think that all makes sense Chris.

Thanks

Sent from my iPhone

On 2012-10-26, at 1:53 PM, "Chris Provencal" <cprovencal@dartaero.com> wrote:

We're sending out D412-705-015. The w/o is currently calling up CHG 003. The change record has the latest CHG # at CHG 004 (11.11.10 for the soon to be superseded D3256 Rev. D, see attached). Ignoring that mix-up, I'm assuming the rev of this kit should be CHG 005 (for G-89 mat'l on soon to be released D3256 Rev. E).

I'm going to mark up the kit w/o accordingly unless somebody says otherwise.

-Chris

From: Mike Petsche [<mailto:mpetsche@dartaero.com>]
Sent: Friday, October 26, 2012 1:42 PM
To: Chris Provencal
Cc: David Shepherd
Subject: Re: Drive shaft tunnel gasket change

Marc should have an email from david somewhere saying this stuff is ok. It was about two weeks ago I think.

Come to think of it Melanie might have it too.

Sent from my iPhone

On 2012-10-26, at 1:36 PM, "Chris Provencal" <cprovencal@dartaero.com> wrote:

David,

Dwg D3256-3 Gasket for kit D412-705-015, the want to ship out a kit with the new 0.060" G-89 mat'l. Everyone is telling me this is OK, I just checked Marc's dwg with this update, but I can't sign off the kit without authorization from you that everything is good, flame tested, etc.

I'm assuming the change number will increase because of this change.

-Chris

<Pages from 705.pdf>

Marc Bellavance

From: David Shepherd <dshepherd@dartaero.com>
Sent: Monday, October 15, 2012 12:14 PM
To: 'Mike Petsche'
Subject: RE: lead time for d412-705-015

Mike,

It is acceptable to use the ThermoChem G89 in place of the Durabla Black for the D3256-3 Gasket that is used in the D412-705-015 Driveshaft Tunnel Kit.

David

From: Mike Petsche [<mailto:mpetsche@dartaero.com>]
Sent: October-15-12 7:47 AM
To: 'David Shepherd'
Subject: FW: lead time for d412-705-015
Importance: High

David

Could you write me a little email saying it's ok to swap that insulation stuff for the stuff from the driveshaft tunnel

ie: Replace the Durablack with the Thermo chem G89

They want to ship another order

Thanks

(And Marc is working on the dwg update)

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Monday, October 15, 2012 9:00 AM
To: 'Marc Bellavance'; 'Petsche, Mike'
Cc: rmolnar@dartaero.com
Subject: RE: lead time for d412-705-015
Importance: High

We received the order, so can we ship??

From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]
Sent: October-12-12 2:26 PM
To: Petsche, Mike
Cc: Lacelle, Linda
Subject: FW: lead time for d412-705-015

Mike, the Kits for Falcon were shipped, this one is for another customer...
Can you get David's blessing or is it best to hold off until end of next week once we have revised and approved drawings?

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Friday, October 12, 2012 2:23 PM
To: 'Marc Bellavance'
Subject: RE: lead time for d412-705-015

Yes, this is for a new request

From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]
Sent: October-12-12 1:11 PM
To: 'Linda Lacelle'
Subject: RE: lead time for d412-705-015

They weren't shipped yet?
Mike signed off mat'l changed on the W/O's...

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Friday, October 12, 2012 12:48 PM
To: Marc Bellavance
Subject: FW: lead time for d412-705-015

Can we ship these now?

From: Alison Bates [<mailto:abates@darths.com>]
Sent: October-12-12 11:40 AM
To: Linda Lacelle
Cc: 'Fauteux, Melanie'
Subject: lead time for d412-705-015

Please advise

Alison Bates
Customer Support Representative
Sales



W: 613.632-3336
F : 613.632.4443
email@darths.com
www.darthelicopterservices.com

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Marc Bellavance

From: David Shepherd <dshepherd@dartaero.com>
Sent: Monday, October 15, 2012 12:14 PM
To: 'Mike Petsche'
Subject: RE: lead time for d412-705-015

Mike,

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Sent: October-15-12 7:47 AM
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Cc: rmolnar@dartaero.com
Subject: RE: lead time for d412-705-015
Importance: High

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From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]
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To: Petsche, Mike
Cc: Lacelle, Linda
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To: 'Marc Bellavance'
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Subject: FW: lead time for d412-705-015

Can we ship these now?

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Sent: October-12-12 11:40 AM
To: Linda Lacelle
Cc: 'Fauteux, Melanie'
Subject: lead time for d412-705-015

Please advise

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